



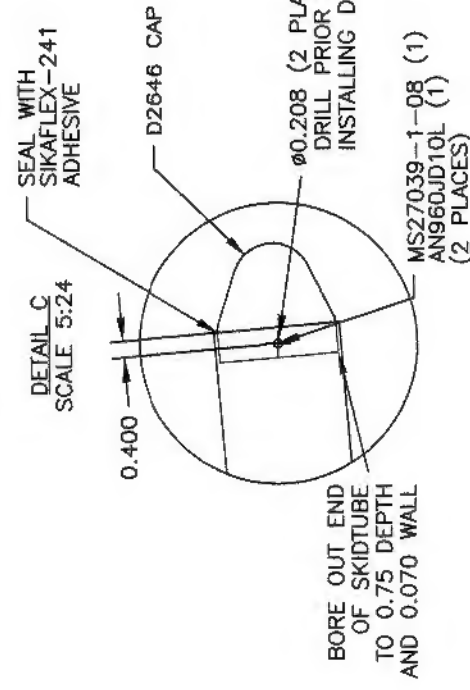
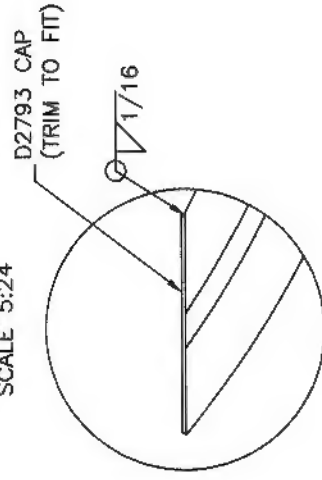
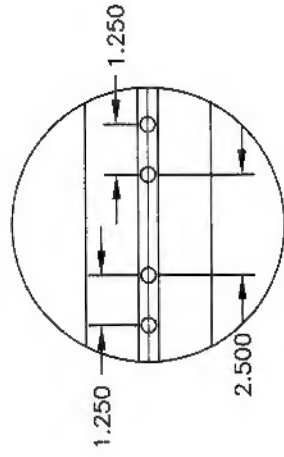
DESIGN #1	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #1	APPROVED [Signature]	DRAWING NO. D2790	REV. B SHEET 1 OF 2
DATE 98.11.26		TITLE 427 FLOAT SKIDTUBE ASSEMBLY SCALE NTS	
A	98.08.13	NEW ISSUE	
B	98.11.26	R30.0 WAS R18.5	

RELEASED
99.03.01 DS

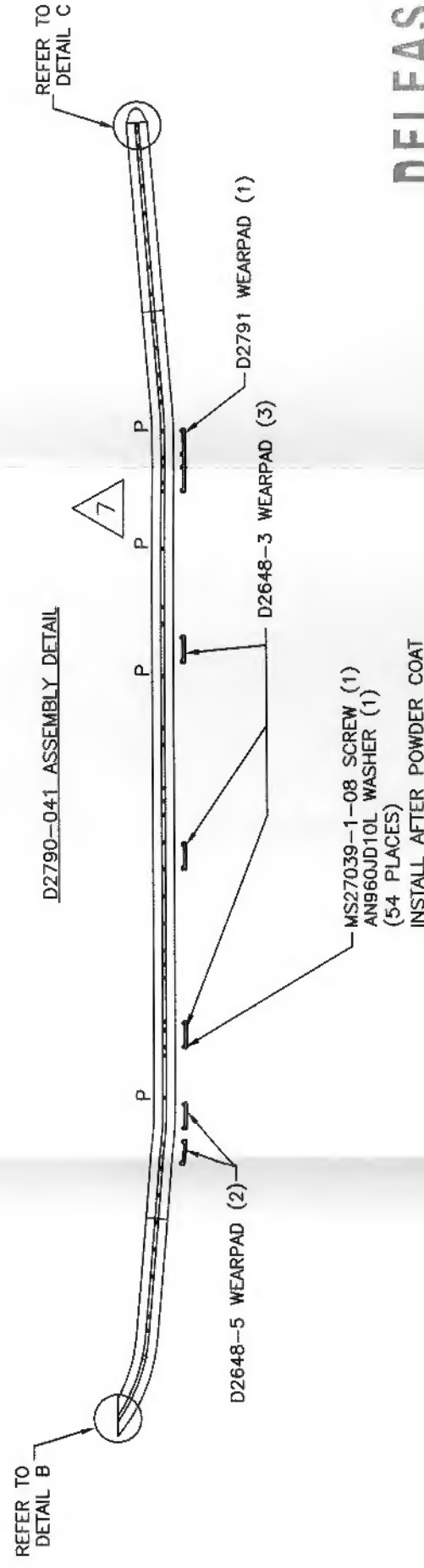
Qty	Part Number	Description
X	D2790-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
3	D2648-3	WEARPAD
2	D2648-5	WEARPAD
49	D2649	CROSS BOLT SPACER
8	D2651-1	PLUG
8	D2651-3	O-RING
1	D2789	WEB
1	D2791	WEARPAD
1	D2793	CAP
54	ALS4-1032-130 or AKS7-1032-130	INSERT
56	AN960JD10L	WASHER
56	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 200 INCHES.*
- 3) INSERT D2789 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING.
- 4) USE DART DRILL TEMPLATE DT8161 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS4-1032-130 PER SECTION D-D (54 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2789 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (8 PLACES).



ALS4-1032-130 (REF)
(TYP 54 PLACES)



**AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:**

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER (49 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2649 SPACER TO Ø.313 X 0.75 DEEP

DESIGN 	DRAWN BY 	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED 	APPROVED 		DRAWING NO. D2790
DATE 98.11.26	TITLE 427 FLOAT SKIDTUBE ASSEMBLY		SHEET 2 OF 2
			SCALE 1:24